

Work Order ID 53284

October 30, 2009 1:21:28 PM

Page 1

Item ID: D206-642-441

Accept

Setup Start

Revision ID: F

Stop

Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A

Work Order ID 53284

October 30, 2009 1:21:28 PM



Page 2

Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube								
	2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650								
	3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. A/R <input type="checkbox"/> Aluminum Rod <input checked="" type="checkbox"/> M112507/M111999 BE 09/11/02								
	4-Grind weld flush to cap on top surface only. BE 09/11/02								
	5-Cut aft end 138.60" from front of tube								
	6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".								
	7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".								
	8-Open using #6 Drill Bit								
	9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail								
	10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650								
	11-Deburr and Blow out all chips form inside the tube								

1 M9/11/2

1 K 9/11/3

Work Order ID 53284

October 30, 2009 1:21:28 PM



Page 3

Item ID: D206-642-441
Revision ID: F
Item Name: Replacement Skidtube

Accept



Setup Start



Stop



Start Date: 29/10/2009 Start Qty: 1.00
Required Date: 09/11/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 Skidtubes Skidtubes	QC 5 Memo Install D2680-041 Nut plate as per Dwg 09/11/03	0.00 0.00	27	8	09/11/03				
130 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	27	8	09/11/03				

- Chemical conversion

AW 9-11-3

- QC 3

DP

9-11-3

Work Order ID 53284

October 30, 2009 1:21:28 PM



Page 4

Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.

cure time before cutting

Start Date: 9-11-03 Time: 3:30

Finish Date: 9-11-04 Time: 8:45 am

A/R ☐ Sikaflex-291 ☐ 112391

Sikaflex expiry date: 10-02-20

- ARM 9-11-03

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Salubay



Work Order ID 53284

October 30, 2009 1:21:28 PM



Page 5

Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
A/R ☐ Aluminum Rod M112507 *BE 09/11/05*

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur

1 H 9/11/5

165

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

2) S. Carlos

(X)

Work Order ID 53284

October 30, 2009 1:21:28 PM



Page 6

Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

170

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D2650

1 49/11/15

180

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

2) Sorkulov



4

190

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

2) Sorkulov



4

Work Order ID 53284

October 30, 2009 1:21:28 PM



Page 7

Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Pressure Wash per QSI005 4.3

0.00

M 09/11/06



HandFinish

Memo

0.00

Hand Finishing

Touchup Alodine M 09/11/06 (U) P

205

Spray Painting per QSI005 4.2

0.00



SprayPaint

Memo

0.00

Spray Painting

PRIME GREY 110918
SPRAY PAINT DELFLEET BLUE 110077
CLEAR DELFLEET 113088

09

11

11



215

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

R 09-11-12

Work Order ID 53284

October 30, 2009 1:21:28 PM



Page 8

Item ID: D206-642-441
Revision ID: F
Item Name: Replacement Skidtube

Accept



Setup Start



Stop



Start Date: 29/10/2009 Start Qty: 1.00
Required Date: 09/11/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
	HandFinish								
Hand Finishing	<p>Memo</p> <p>1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wear plate. A/R <input type="checkbox"/> Sikaflex-291 <input checked="" type="checkbox"/> <u>11/12/2009</u> Sikaflex expiry date: <input type="checkbox"/> <u>10/01</u></p> <p>2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive</p> <p>3-Install MS27039-4-06 Screw as per DEO 9153</p> <p>4-Inspect for foreign object per QSI 024</p> <p>5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive A/R <input type="checkbox"/> Sikaflex-291 <input checked="" type="checkbox"/> <u>11/12/2009</u> Sikaflex expiry date: <input type="checkbox"/> <u>10/01</u></p> <p>6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4 Batch: <u>112603</u></p>	0.00							

BT 09-11-13

Work Order ID 53284

October 30, 2009 1:21:28 PM



Page 9

Item ID: D206-642-441
Revision ID: F
Item Name: Replacement Skidtube

Accept



Setup Start



Stop



Start Date: 29/10/2009 Start Qty: 1.00
Required Date: 09/11/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00				(40)	4		
Quality Control									
250	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-441 Location: _____ PPP Rev: _____								
260	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

2) 502/4/16

PP B53289

9/11/18 SP

09/11/19

u 29.11.18

Picklist Print

October 30, 2009 1:21:32 PM

Page 1

Work Order ID: 53284



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2620RevB 		Manufactured	No			110	Each	13.0000	1.0000			
Skidtube, 206 Skidtube												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

13

45898

13

1 11/11/2

D2646RevC



Manufactured No

120

Each

44.0000

1.0000



Aft Cap

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

44

20208

0

43801

1

46327

4

48109

39

1 BR 09-11-12.

D2647RevF



Manufactured No

140

Each

23.0000

1.0000



Cap

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

23

10773

7

43846

16

1 BG 09/11/02

Picklist Print

Page 2

October 30, 2009 1:21:32 PM

Work Order ID: 53284



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2654-7RevE1		Manufactured	No			160	Each	2.0000	1.0000			
--------------	--	--------------	----	--	--	-----	------	--------	--------	--	--	--



Web

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

2

52801

2

CCR264SS3-3

Purchased

No

170

Each

65.0000

2.0000



Cherry Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

65

111548

38

111827

1

112314

26

51)
AUM 9-11-02
B-52917

2 11/11/15

October 30, 2009 1:21:32 PM

Shop Packet Print

Page 2

Picklist Print

October 30, 2009 1:21:32 PM

Work Order ID: 53284



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2649RevB1		Manufactured	No			170	Each	476.0000	23.0000			

Cross Bolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	83	
51529	83	
Main Warehouse		
ST	393	
36013	5	
47112	382	
48271	6	

23 BE 09/11/05

D2680-041RevB1

Manufactured No

170

Each

75.0000

1.0000



Nut Plate

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	75	
33061	10	
44086	65	

1 n 9/11/05

Picklist Print

Page 4

October 30, 2009 1:21:32 PM

Work Order ID: #53284



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No			230	Each	5,073.000	60.0000			



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5073

110511 ✓

5073

AN960JD10L AN960C10L M112 612

Purchased

No

230

Each

5,735.000

62.0000



Washer

409.11.12

60

BR 09-11-12

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5735

101291

16

104885

153

105793

236

109632 ✓

420

110985

4910

AN960JD10L

2

BR 09-11-12

PTO

October 30, 2009 1:21:32 PM

Shop Packet Print

Page 4

W/O: 53284		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
05.11.12	230	Qty (60) AN960 JD10L REPLACED WITH Qty (60) AN960 C10L M112 G12	BZ	09-11-12	60	05.11.12 AS1 0412	S 04/11/12

Part No: D206-642-441 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 30, 2009 1:21:32 PM

Work Order ID: 53284



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416 		Purchased	No			230	Each	4,591.000	1.0000			
Washer												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	4591	
108161	519	
110523	340	
111279	101	
111916	482	
112314 ✓	3149	
16941	0	

1 BL 09-11-13.

CR3212-4-03

Purchased

No

230

Each

292.0000 2.0000



Cherry Rivet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	292	
111359	92	
112314	200	

2 11/11/15

Picklist Print

Page 6

October 30, 2009 1:21:32 PM

Work Order ID: 53284



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2651-1RevB		Manufactured	No			230	Each	359.0000	22.0000			

Plug

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST 53349	359	
43990	81	
45490 ✓	28	
51530	250	

16 BL 09-11-13.

6 OK 09-11-13

D2651-3RevB

Manufactured No

230

Each

991.0000

22.0000



O-Ring

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	991	
43849	3	
46114 ✓	988	

22 BL 09-11-13.

October 30, 2009 1:21:32 PM

Shop Packet Print

Page 6

Picklist Print

Page 7

October 30, 2009 1:21:32 PM

Work Order ID: 53284



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-15RevB		Manufactured	No			230	Each	22.0000	1.0000			

Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

17

51671 ✓

17

Main Warehouse

ST

5

30750

4

42233

1

D3535-23RevB

Manufactured No

230

Each

15.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

13

51618 ✓

13

Main Warehouse

ST

2

48156

2

October 30, 2009 1:21:32 PM

Shop Packet Print

Page 7

Picklist Print

Page 8

October 30, 2009 1:21:32 PM

Work Order ID: 53284



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-37RevB		Manufactured	No			230	Each	18.0000	1.0000			
Wearshoe												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

13

51654

13

Main Warehouse

ST

5

47374 ✓

5

1 Bl 09-11-13.

D3536-15RevA

Manufactured No



230

Each

32.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

32

48159

6

51600 ✓

26

1 Bl 09-11-13.

Picklist Print

Page 9

October 30, 2009 1:21:32 PM

Work Order ID: 53284



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3536-23RevA

Manufactured

No

230

Each

21.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

12

51609 ✓

12

Main Warehouse

ST

9

30754

1

47713

8

D3536-37RevA

Manufactured

No

230

Each

20.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

20

47375 ✓

7

51641

13

1 BR 09-11-13.

1 BR 09-11-13.

Picklist Print

October 30, 2009 1:21:32 PM

Work Order ID: 53284



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3537-1RevC

Manufactured

No

230

Each

299.0000

6.0000



Wearpad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

2

48288

2

Main Warehouse

FP17

297

51624

30

51678 ✓

162

51679

105

6 BL 09-11-13.

D3537-3RevC

Manufactured

No

230

Each

60.0000

1.0000



Wearpad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

60

30758

7

33881 ✓

17

35697

36

1 BL 09-11-13.

Picklist Print

October 30, 2009 1:21:32 PM

Work Order ID: 53284



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS27039-1-08 Purchased No 230 Each 2,947.000 2.0000



Screw

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2947	
110467 ✓	188	
110552	759	
110835	2000	

2 Bl 09-11-13.

MS27039-4-06 Purchased No 230 Each 75.0000 1.0000



Screw

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	75	
109061 ✓	75	

1 Bl 09-11-13.

MS27039C1-08 Purchased No 230 Each 962.0000 60.0000



SCREW

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	962	
19185 ✓	962	

60 Bl 09-11-13.

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X			1	D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

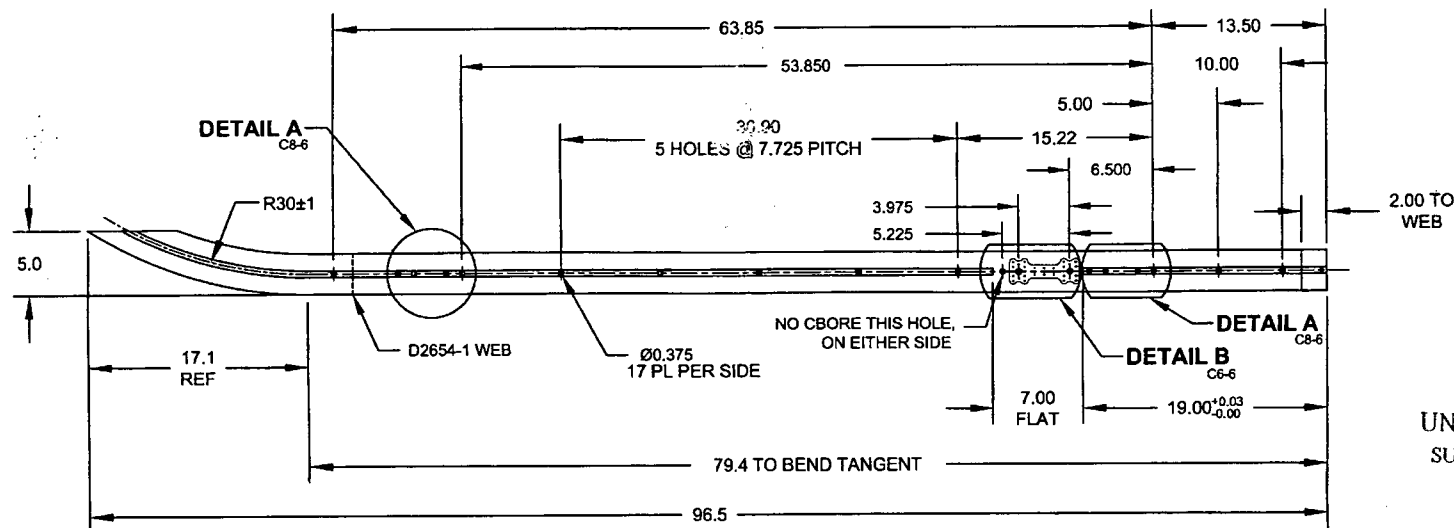
F

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53284

RELEASED
08.07.23

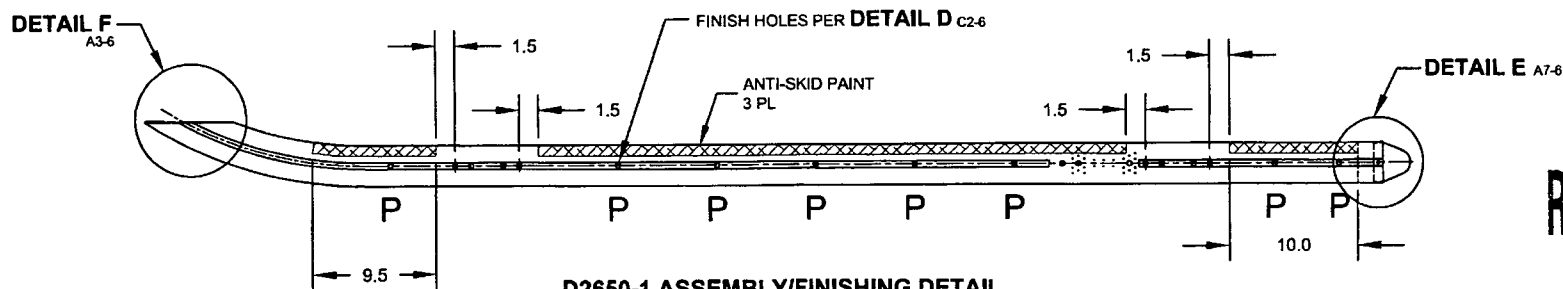
NOTES:
MATERIAL: N/A
FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: NONE
WEIGHT: N/A
WELD PER DART QSI 004
DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D2650-1 BENDING/DRILLING DETAIL

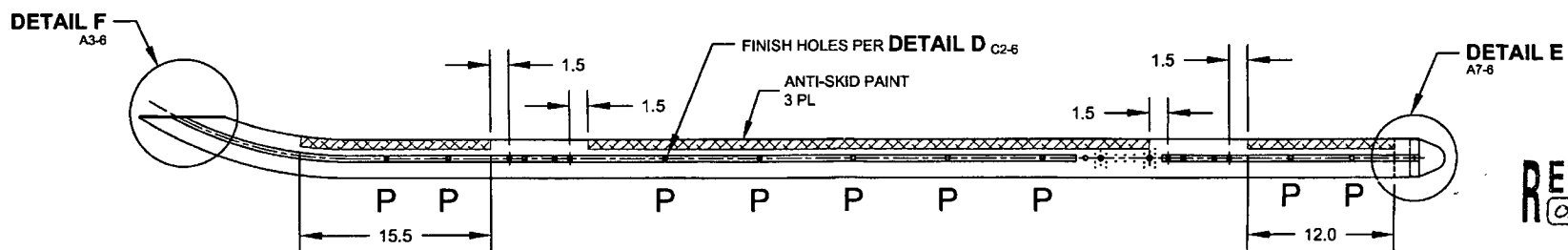
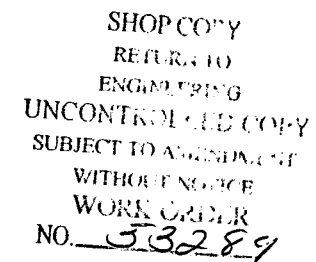
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53284







D2650-1 ASSEMBLY/FINISHING DETAIL

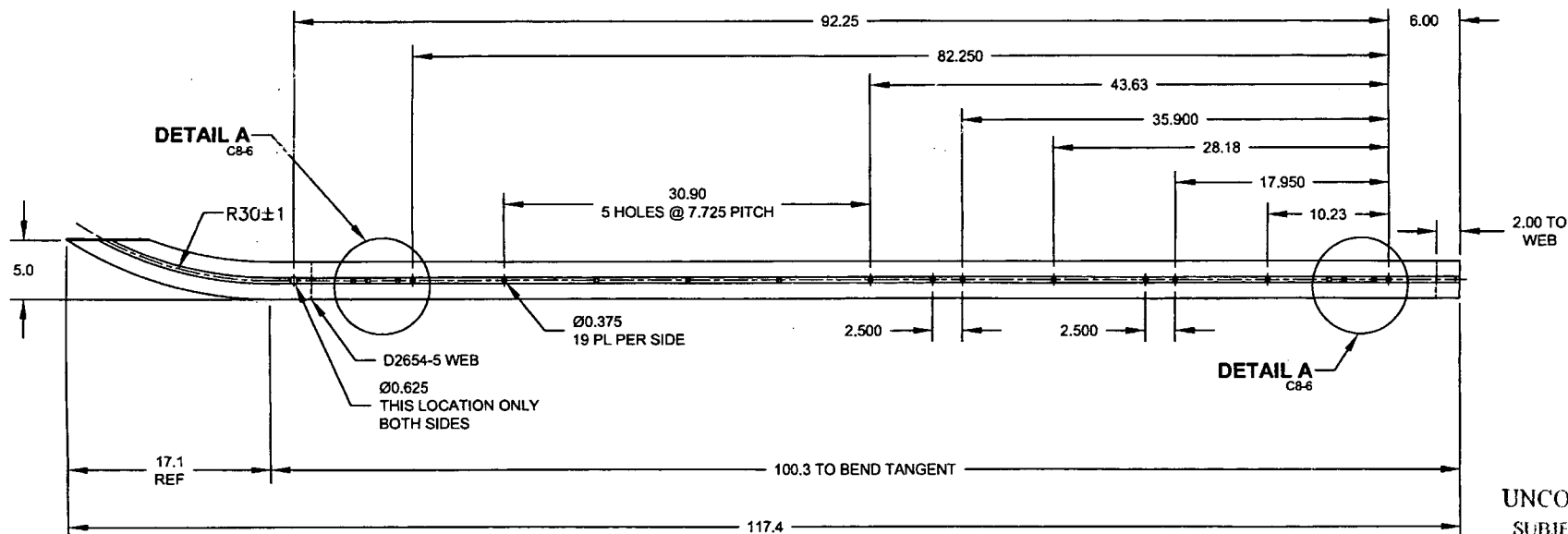
RELEASED
68 09 22 14

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

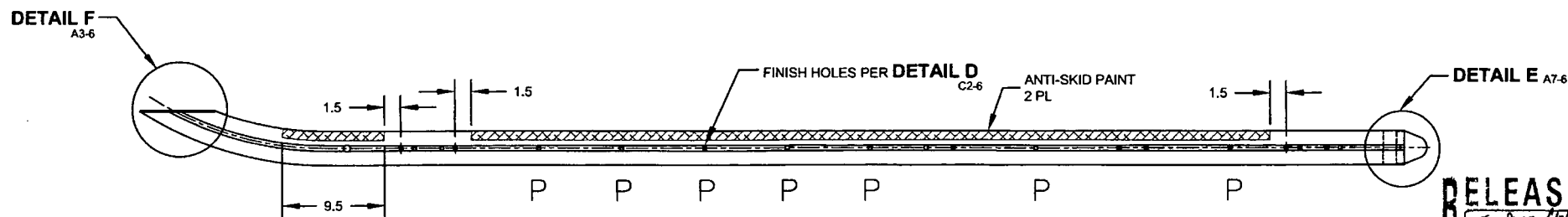


DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1987 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

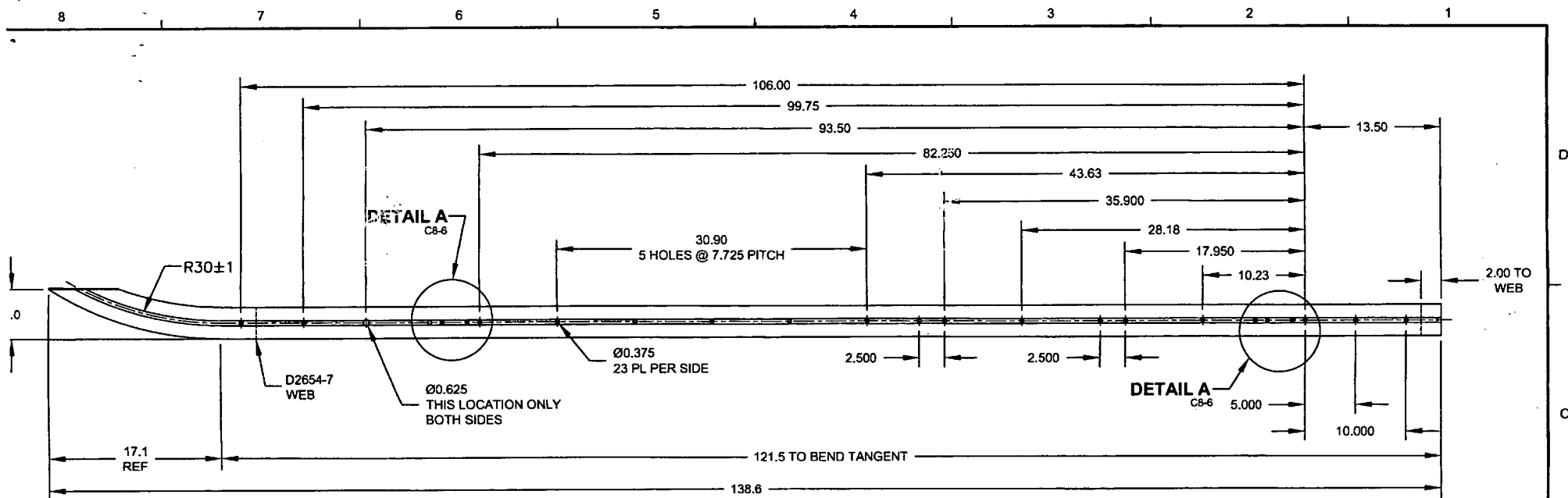


D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

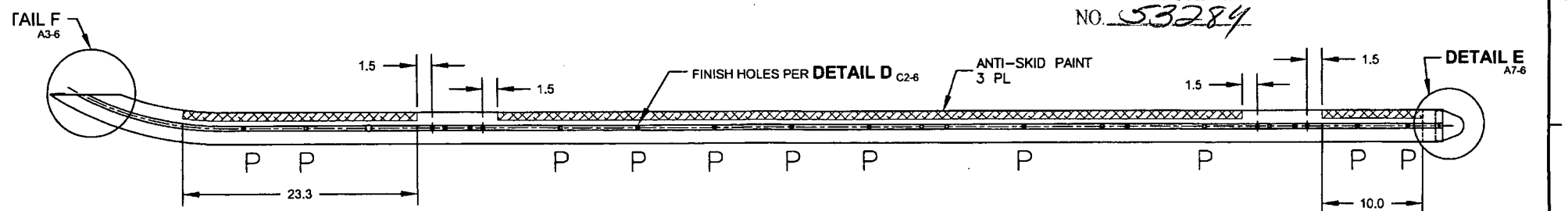
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



D2650-7 BENDING/DRILL DETAIL

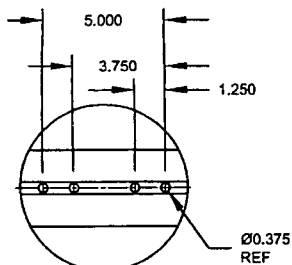
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53284

RELEASED
07-07-22

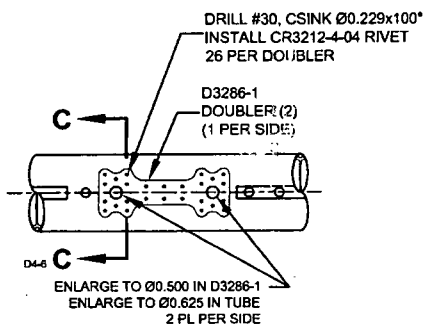


D2650-7 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

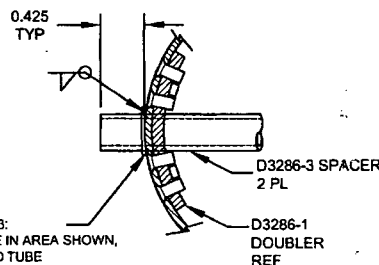


DETAIL A C2-2
SCALE 2X D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5

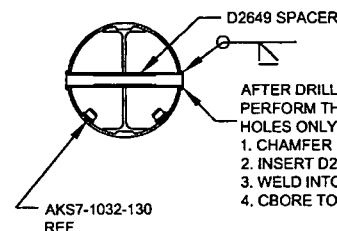


DETAIL B C3-2
SCALE 2X C3-3

SECTION C-C C7-6
SCALE NONE

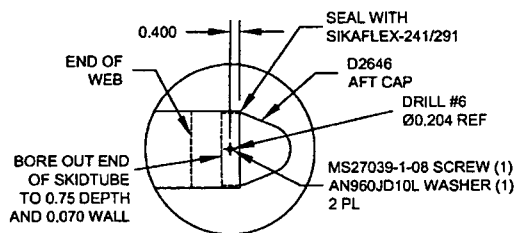


- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.

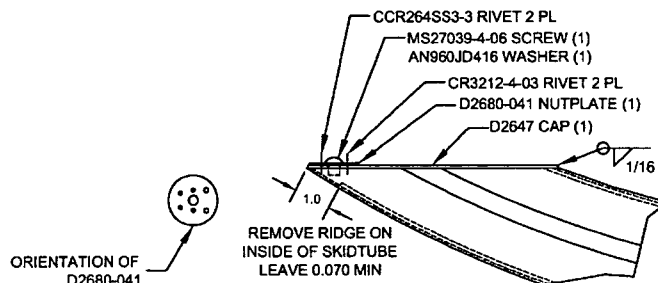


DETAIL D B4-2
FOR Ø0.375 HOLES ONLY B4-3
SCALE 3X B4-4
B4-5

- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP



DETAIL E B2-2
SCALE 2X B2-3
B1-4
B1-5







DETAIL F B8-2
SCALE NONE B8-3
B8-4
B8-5

DETAIL F NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
05-09-22-10

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1987 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53289

NO. 214

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 52855
Part number: D206-642-251
Description: 206 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Rob Dunt Date of Test Coupon 09.10.29

Welder Barclay Elliott Date of Test Coupon 09.10.29

The above named individual is qualified in accordance with AWS D17.1.2001 to weld